

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011804**Date Inspected:** 04-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard – 9AE.

This QA inspector performed in process visual inspection of the Floor Beam Flange fillet welded to Floor Beam (FB003) on PP72 & PP73 of OBG SEG 9AE. The welds are identified as:

- 1) PP73-SSD19-005.
- 2) PP72-SSD19-004.

This QA Inspector visually discovered two transverse linear indications on Floor Beam Flange to Floor Beam fillet weld identified as PP72-SSD19-004. This was then confirmed by performing Magnetic Particle Testing (MT). One of the indications was observed as approximately 8mm length and the other was observed around 15mm length. ZPMC QA representative Mr. Zhong Wei & ABF representative Mr. Peter Shaw, were verbally notified about this issue & that an incident report would be generated. These welds were previously tested 25% by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date.

For details, refer attached images.

WELDING INSPECTION REPORT

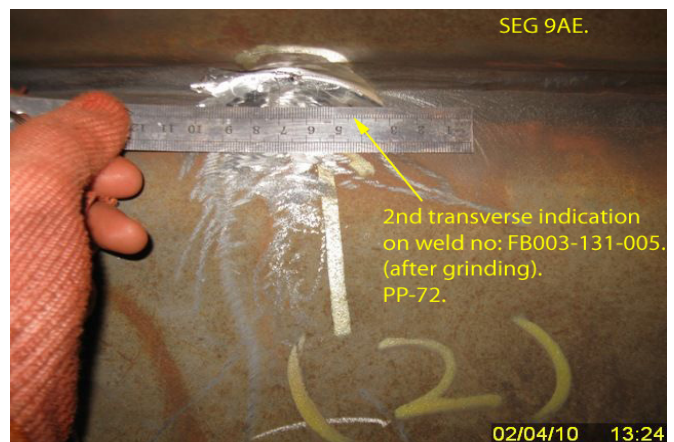
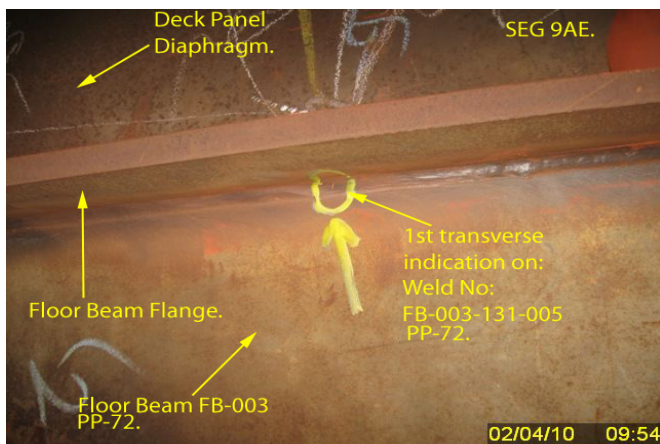
(Continued Page 2 of 3)

Outside Yard: SEG 7DW.

This QA Inspector observed the following work in progress:

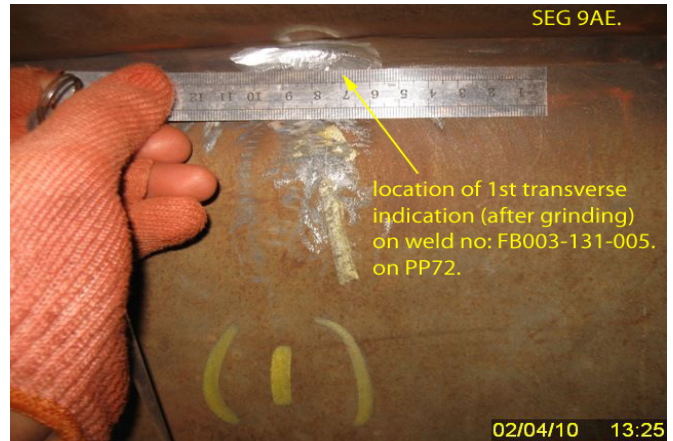
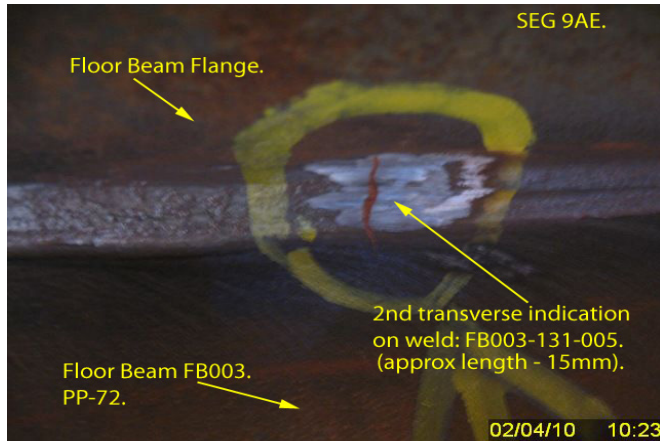
ZPMC performing weld repair / correction on Flange Plate X7k of PP56, PP57 & PP58; to maintain the required radius R50mm. Welding process used was Shielded Metal Arc Welding (SMAW). Welder was identified as 045133. ZPMC QC was identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair, which was used as per Welding Repair Report (WRR) B-WR10642 Dt: 02/03/10.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer